

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000202**Date Inspected:** 11-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:** B49-024-07**Bridge No:** 34-0006**Welder:** Zhu Hai Ping**Witness Lot #:****Component:****ID #:****Joint Description:** B-U2a

N/A

WPS ID #:

PWPS-B-T-3112

N/A

Base Metal: A709 Grade 485 (HPS 70)

N/A

PQR ID #:

HP200777

N/A

Thickness: 75mm

N/A

Process:

SMAW

N/A

Electrode Spec/Class: AWS A5.5/9018M-H4R

N/A

Positions:

3G

N/A

Backing Material: A709 Grade 485 (HPS 70)

N/A

CWI:

Song Wei Min

N/A

Average Amps: 172.7

N/A

AWS Code:

D1.5 2002

N/A

Average Volts: 22

N/A

Applicable Sec:

5.13

N/A

Travel Speed: 72.9

N/A

Heat Input:

3.13 KJ/mm

N/A

Preheat: 180 deg. C min/230 deg. C max.

N/A

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of a procedure qualification (PQR) test plate using shield metal arc welding (SMAW), Lincoln (Excalibur), and classification E9018M-H4R. The welding was performed in accordance with AWS D1.5 2002, Section 5.13 requirements. The welding appeared to comply with the project documents. The completed weld test was visually inspected by American Bridge/Fluor, Quality Control (QC) subcontractor, Bureau Veritas (BV) inspector, Mr. Song Wei min and accepted for conformance per AWS D1.5 2002 requirements.

Summary of Conversations:

As identified with in the contents of this report.

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

(Continued Page 2 of 2)

Inspected By:	Hasler,Mike	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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